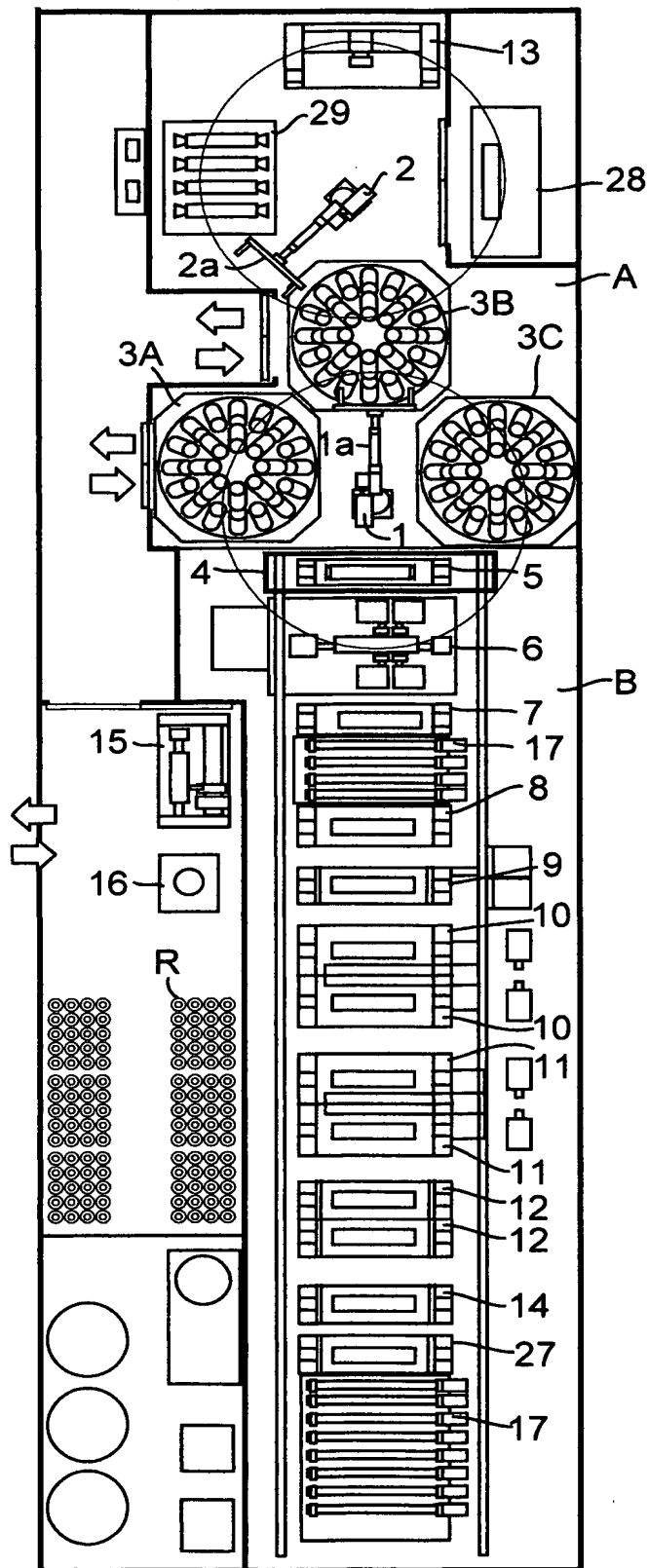
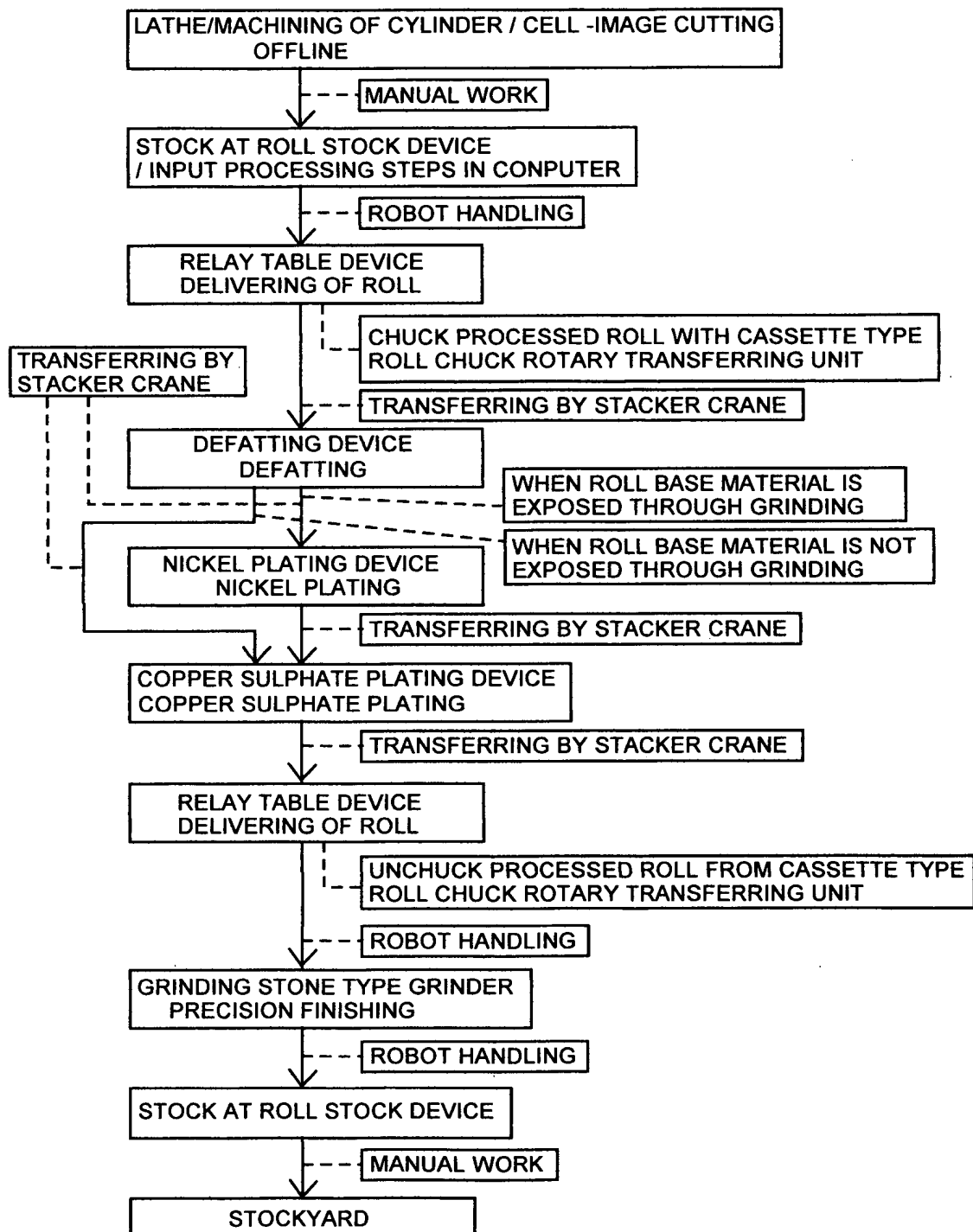


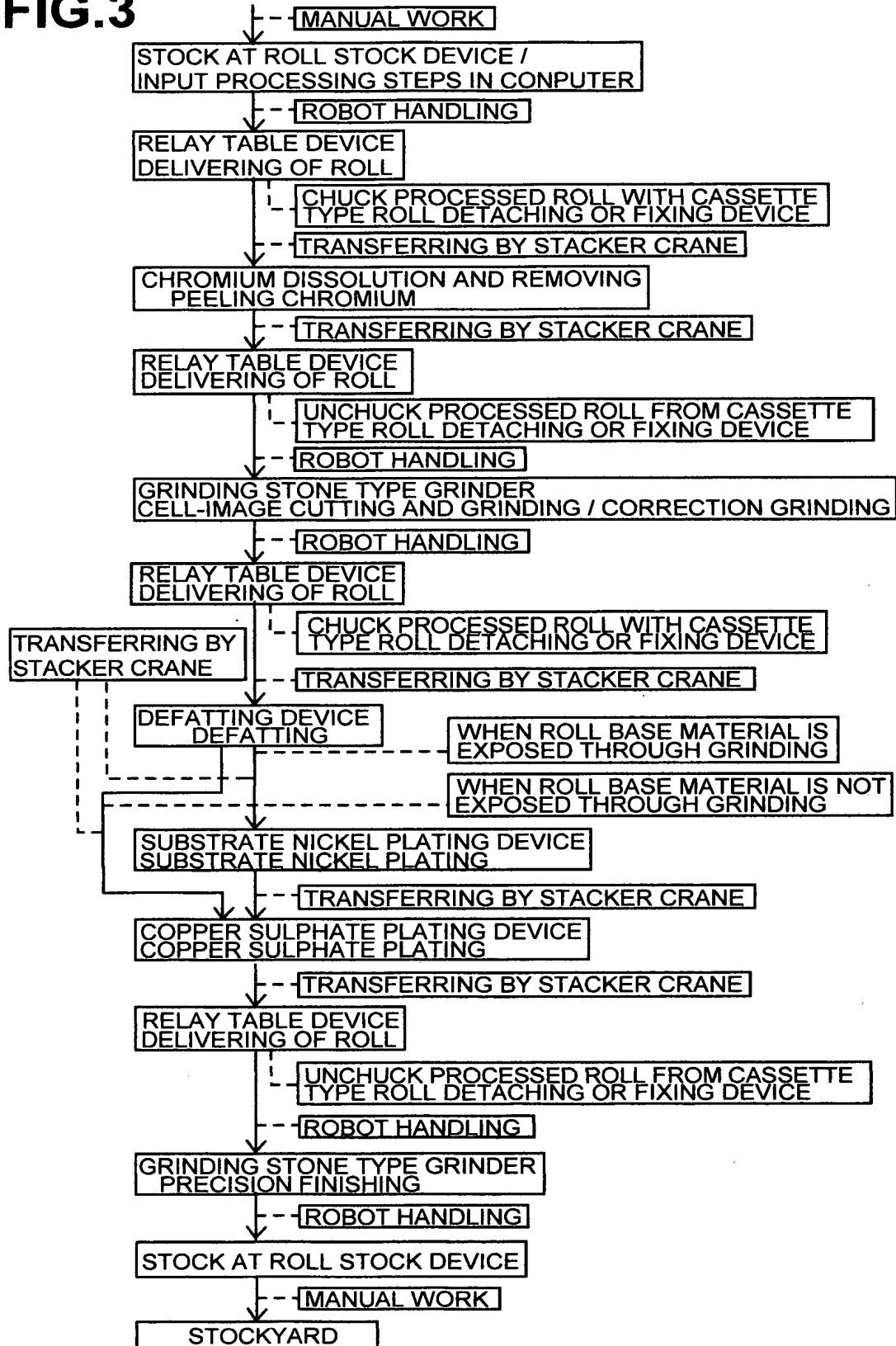
**FIG.1**



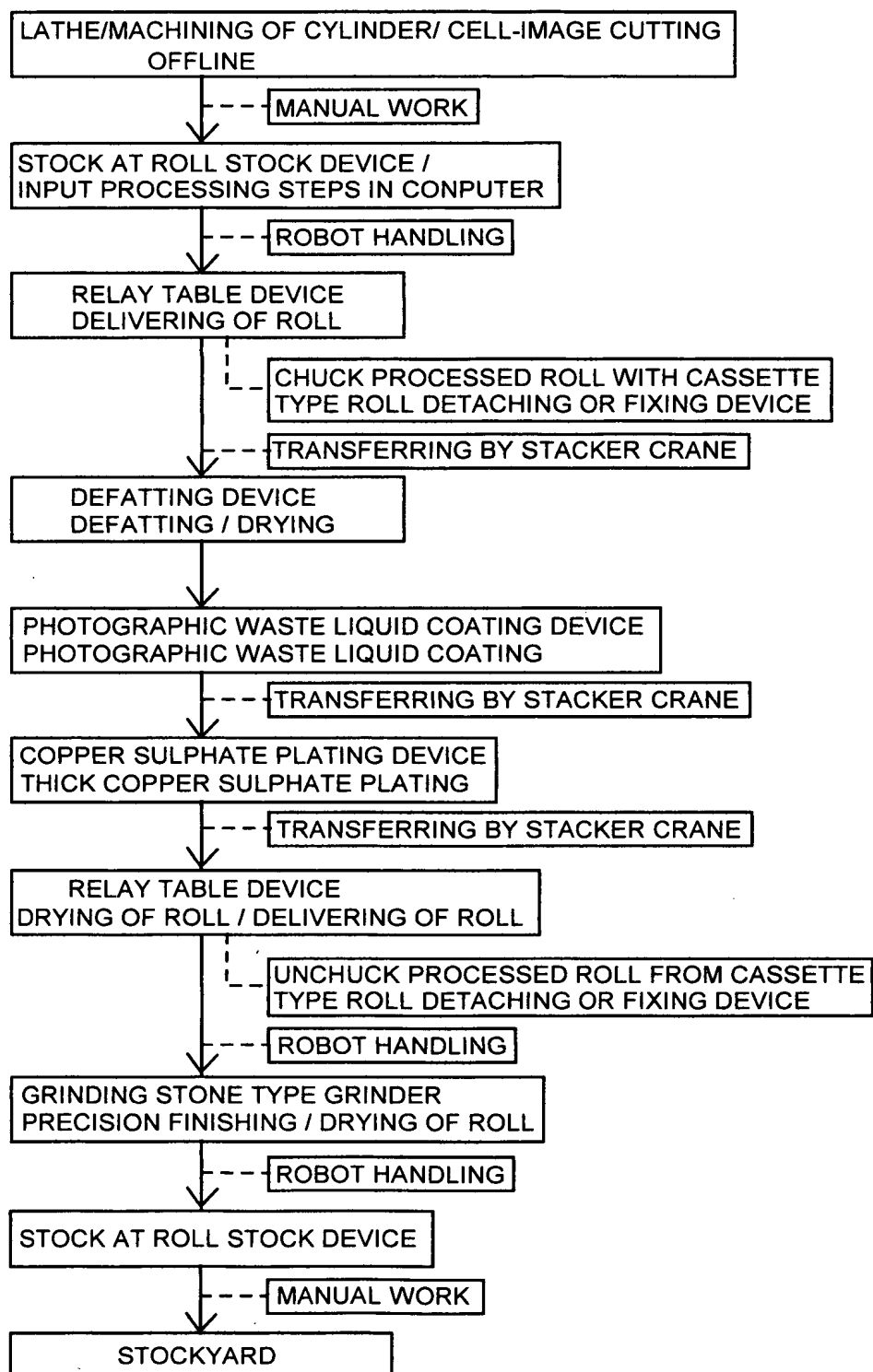
**FIG.2**



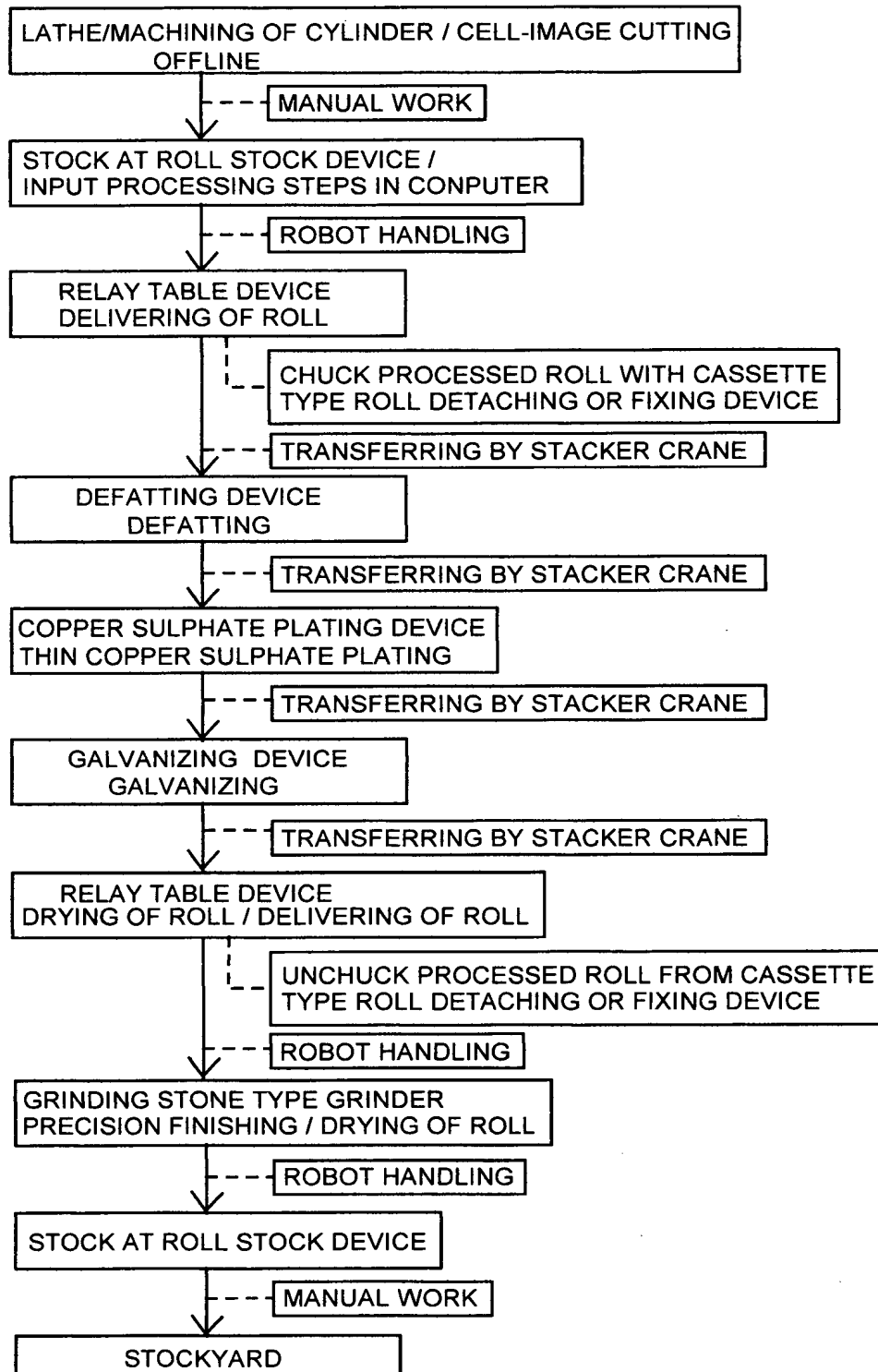
**FIG.3**



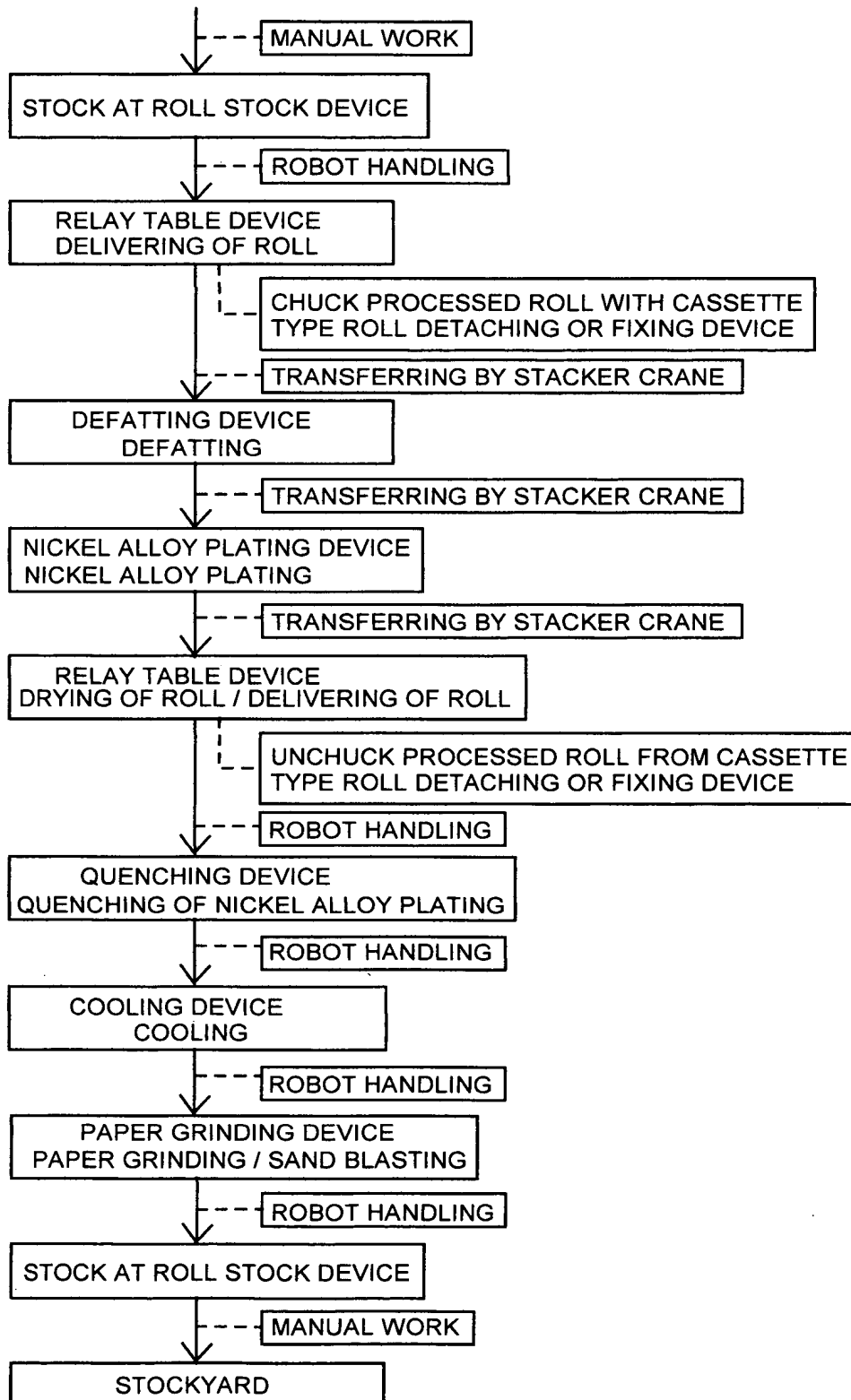
# FIG.4



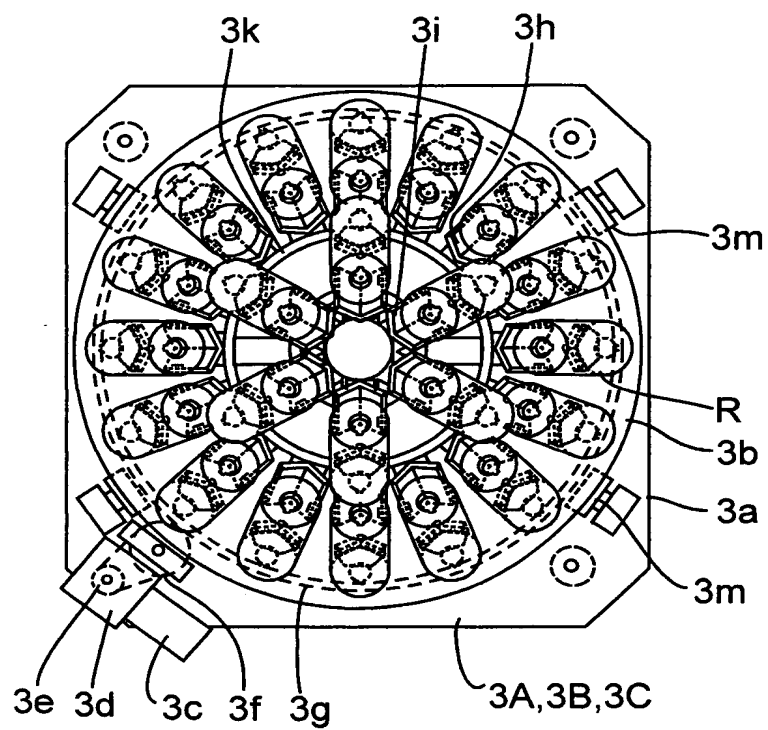
**FIG.5**



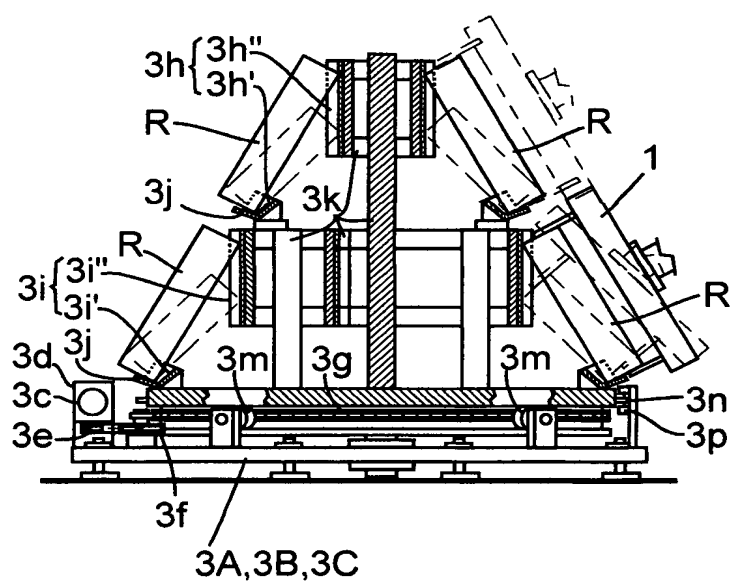
**FIG.6**



# FIG.7



# FIG.8

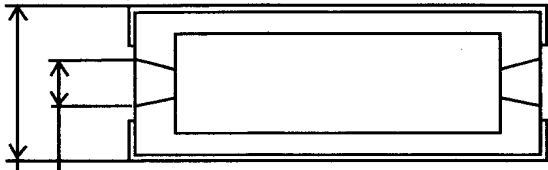


# FIG.9

Data Input Sheet

Roll Identification No.                     

Roll Length =       .       mm



Chuck Hole Diameter =       .       mm

Roll Diameter =       .       mm

Chromium Plating Thickness =    8     $\mu\text{m}$

Copper Sulphate Plating Thickness =  130   $\mu\text{m}$

Nickel Plating Thickness =    2     $\mu\text{m}$

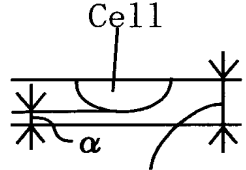
Minimum Cutting Margin =  48   $\mu\text{m}$

Allowable Eccentric Amount =  30   $\mu\text{m}$

Minimum Allowable Copper Sulphate Plating Thickness After Cylindrical Machining =  20   $\mu\text{m}$

Copper Sulphate Plating Thickness Left on Machined End Surface =  60   $\mu\text{m}$

☐ Chuck Automatic
 ☐ Automatic transmission of Measurement
 ☐ Automatic transmission of Machining
 ☐ Measurement Run
 ☐ Set



Cell

$\alpha$

Minimum Cutting Margin  
(Cell Depth +  $\alpha$ )

# FIG.12

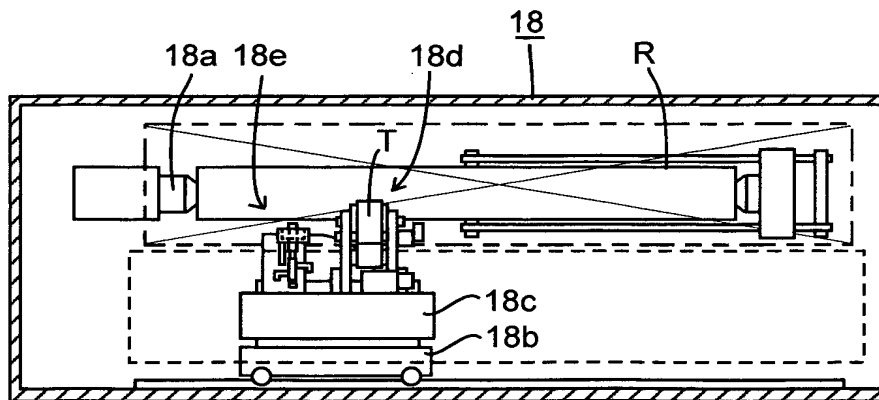
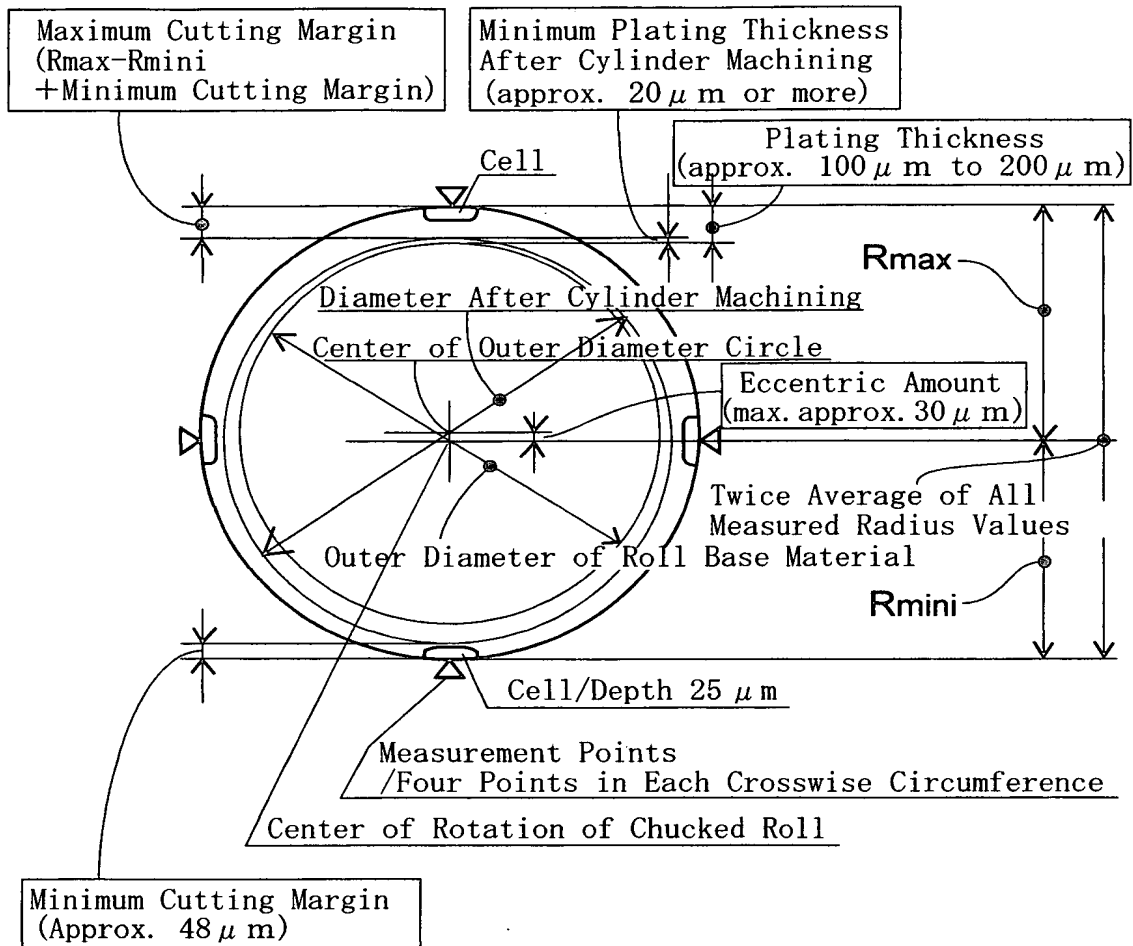
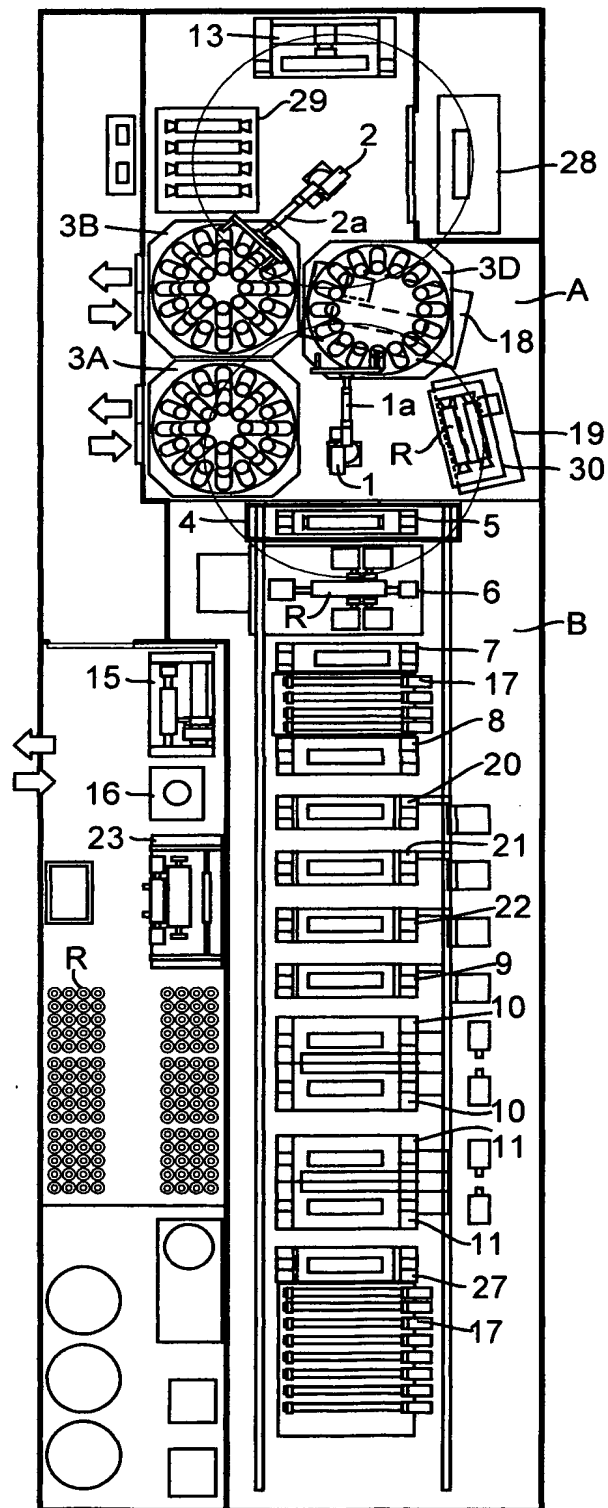




FIG.10



**FIG.11**



# FIG.13

